

# Work Order ID 57572

April 8, 2010 1:43:16 PM



Page 1

Item ID: D3639-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 4/08/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3639

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary

2024 .050

10-4-13

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-4-13

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10-4-13

7

10-7

Dart Aerospace Ltd

W/O: 57572		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/13	#120	Took Qty x1 For QC inspection template	S	10/04/13	x1		S 10/04/13

Part No: D3639-2 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 57572

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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

C'sink as per Dwg D3639

N/A 10.04.13

140



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3639

SP 08/04/13



150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/10/04/16



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57572

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Page 3

Item ID: D3639-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 4/08/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00		10/04/20		7	0		
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00		10-4-20		7			
180  Packaging Packaging	Identify as per dwg & Stock Location: <u>244 A</u>  Memo	0.00 0.00							

10-4-21 7KSD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57572**

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Page 4

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Revision ID:

Stop

Item Name: Doubler

Start Date: 4/08/10

Start Qty: 6.00

Cust Item ID:

Required Date: 4/16/10

Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/22 *[Signature]*  
MF  
10-4-22

# Picklist Print

April 8, 2010 1:43:15 PM

Page 1

Work Order ID: 57572

Parent Item: D3639-2

Parent Item Name: Doubler

Comments: IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

Start Date: 4/08/10

Required Date: 4/16/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	47.0000	1.5095	2.1		



2024-T3 .050 sheet



810-4-13

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT22

47

111381

32

112291

11

113189

4

113189

8



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 57572
<b>Description:</b> Doubler		<b>Part Number:</b> D3639-2
<b>Inspection Dwg:</b> D3639	<b>Rev:</b> A	<b>Page 1 of 1</b>

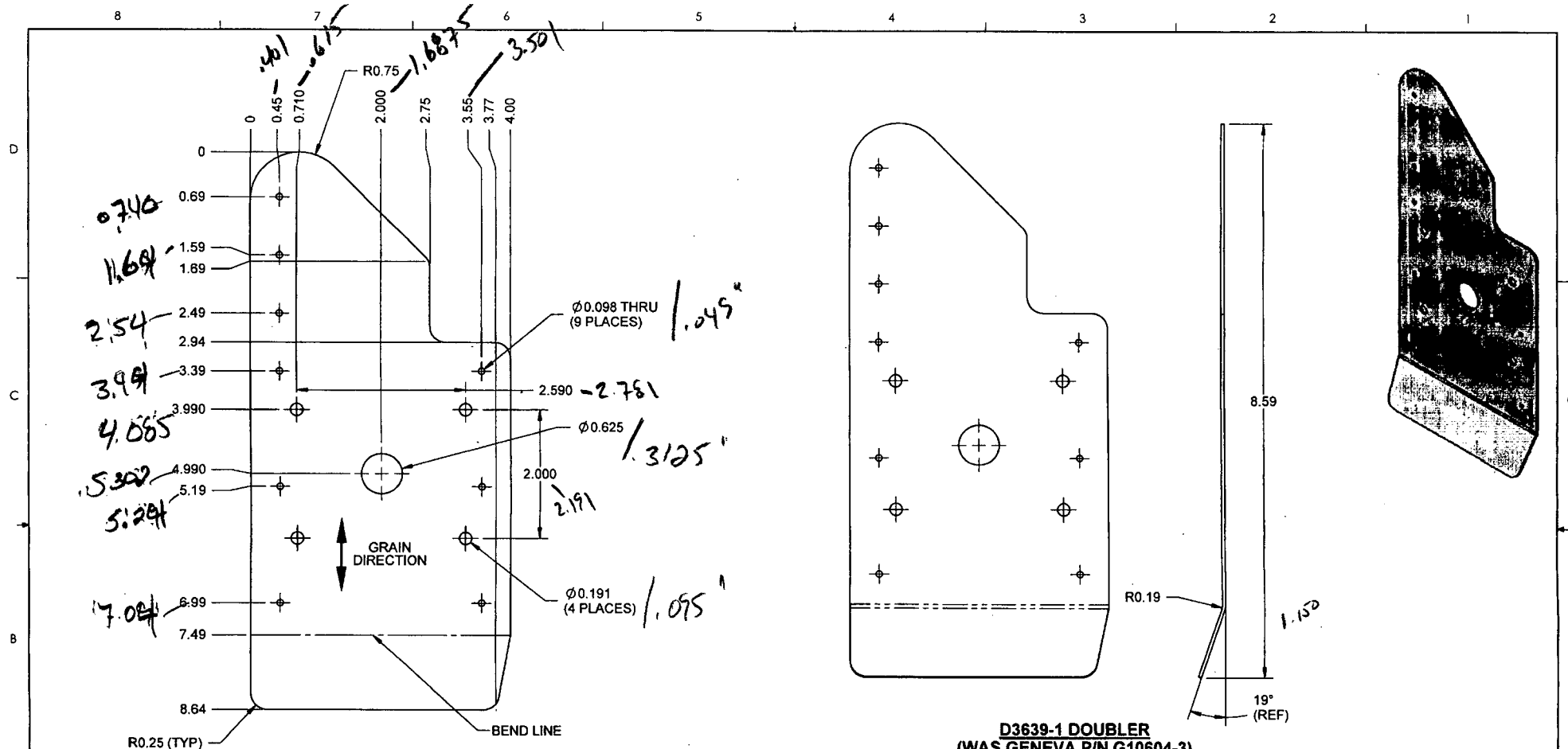
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.628	✓			
Ø0.191	+0.005/-0.001	.193	✗			
Ø0.098	+0.004/-0.001	.100	✗			
0.69	+/-0.030	.683	✗			
1.59	+/-0.030	1.588	✗			
2.49	+/-0.030	2.489	✗			
3.39	+/-0.030	3.377	✗			
3.990	+/-0.010	3.990	✓			
4.990	+/-0.010	4.990	✓			
5.19	+/-0.030	5.190	✓			
6.99	+/-0.030	6.991	✓			
8.64	+/-0.030	8.644	✗			
0.45	+/-0.030	.452	✗			
0.710	+/-0.010	.713	✗			
2.000	+/-0.010	2.000	✗			
2.75	+/-0.030	2.754	✗			
3.55	+/-0.030	3.552	✗			
4.00	+/-0.030	4.008	✗			
2.000	+/-0.010	2.001	✓			
2.590	+/-0.010	2.587	✓			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-4-13	<b>Date:</b> 10/04/13	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	AS



**D3639-1F FLAT PATTERN  
(D3639-2F OPPOSITE)**

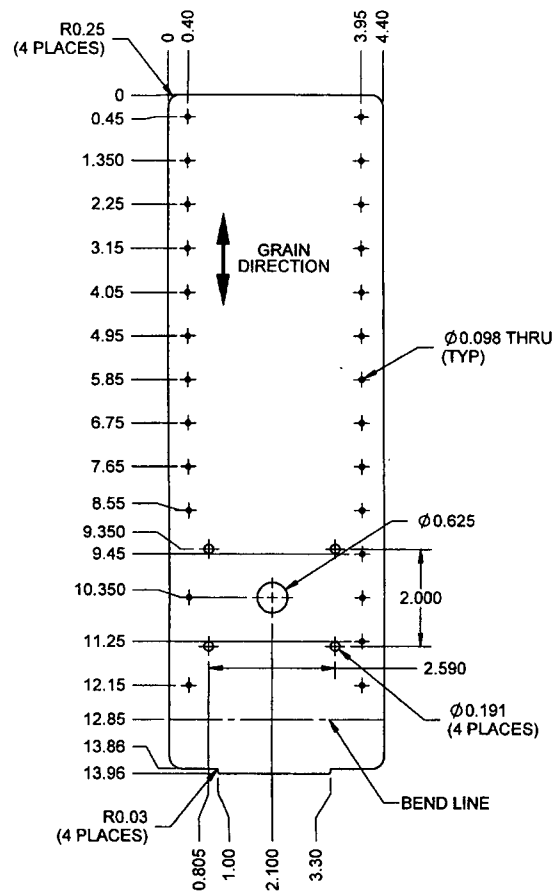
**D3639-1 DOUBLER  
(WAS GENEVA P/N G10604-3)  
D3639-2 OPPOSITE  
(WAS GENEVA P/N G10604-6)**

**RELEASED**  
07.07.27

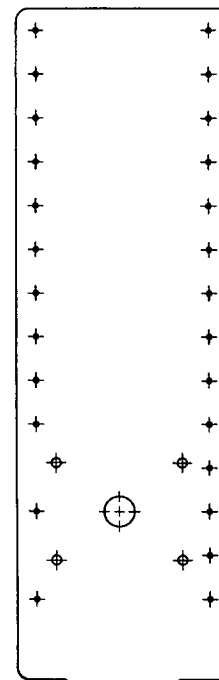
**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

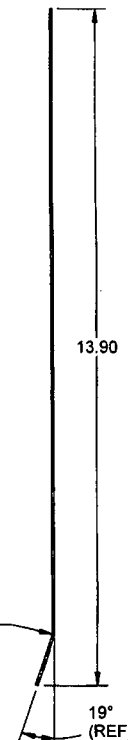
A	NEW ISSUE; REPLACES G10604	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	07.07.27		
<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D3639</b> TITLE <b>DOUBLER</b> REV. A SHEET 1 OF 2 SCALE 2:3 <small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			



**D3639-3F FLAT PATTERN**  
**(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER**  
**(WAS GENEVA P/N G10604-4)**  
**D3639-4 OPPOSITE**  
**(WAS GENEVA P/N G10604-5)**



**RELEASED**  
07.09.07

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	D3639	SHEET 2 OF 2
APPROVED	BE	TITLE	SCALE
DE APPR.	BE	DOUBLER	2.5
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